

Work Order ID: 56855

March 11, 2010 9:52:43 AM



Page 1

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 15/03/2010 Start Qty: 160.00

Required Date: 25/03/2010 Req'd Qty: 160.00



Cust Item ID:

Customer:

Reference:

Good 10 03 11

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev F

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch: 45800

43722

mk 10/03/13

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2230-3

Check for crack while loading into the machine.

2- deburr

mk 10/03/16 160 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mk 10/03/13 160

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

[Handwritten signature]

160 \$

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

[Handwritten signature] 10/03/24

(160) \$

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

[Handwritten signature] 10-3-24

(160) \$

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Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 15/03/2010 Start Qty: 160.00



Cust Item ID:

Required Date: 25/03/2010 Req'd Qty: 160.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

0.00

=> All 10/03/24

(X) 160

Memo

START TIME: 1:00pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 1:30pm

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

PR 10-3-24

(160) 160

Memo

0.00

190



Packaging

Packaging

Identify as per dwg & Stock Location: 476

0.00

Memo

0.00

PR 10/3/24 (160)

Picklist Print

March 11, 2010 9:52:42 AM

Page 1
T

Work Order ID: 56855



Parent Item: D2230-3

Parent Item Name: Lug

Start Date: 15/03/2010

Required Date: 25/03/2010

Comments: IPP D .00.05.18 Added inspection level 8, and removed P/O for powder coat EC

Start Qty: 160.00

Required Qty: 160.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	581.3788	11.5032			



Lug Extrusion

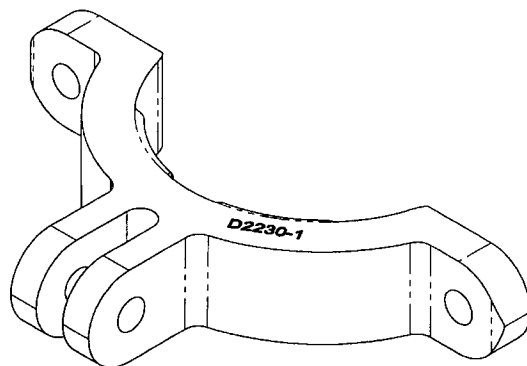


Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	581.3788432	
43722	175.629406	
44529	5.7731	
45800	399.976337	

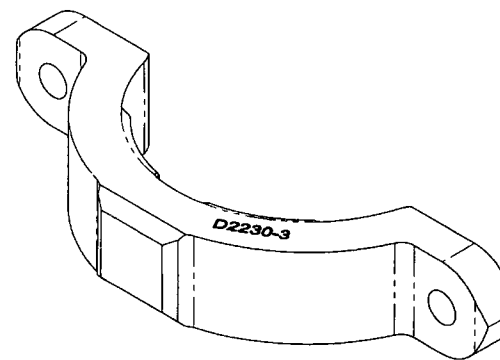
2.166
9.916

OK 10/03/13

43722 = 26" + 6" scrap
45800 = 23" + 7" scrap
45800 = 96" + 6" scrap } Δ P 10/03/11



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

w/o 56855

RELEASED
09/05/15 MP

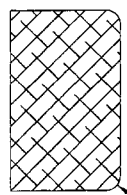
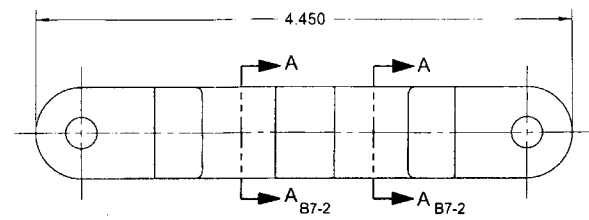
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN		BW	
DRAWN		AJS	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2230	REV. G SHEET 1 OF 3
TITLE MOUNTING LUG	SCALE NTS
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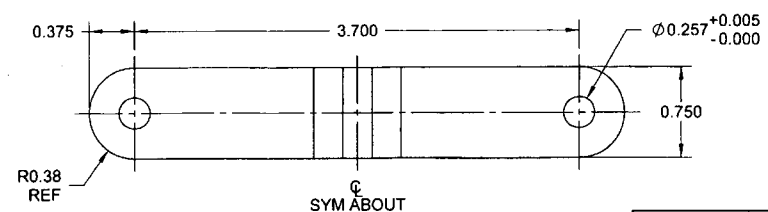
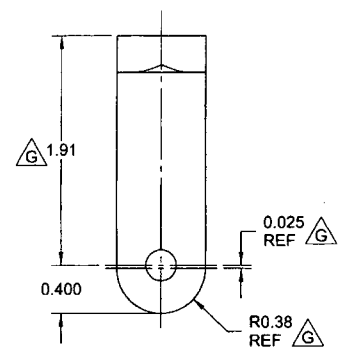
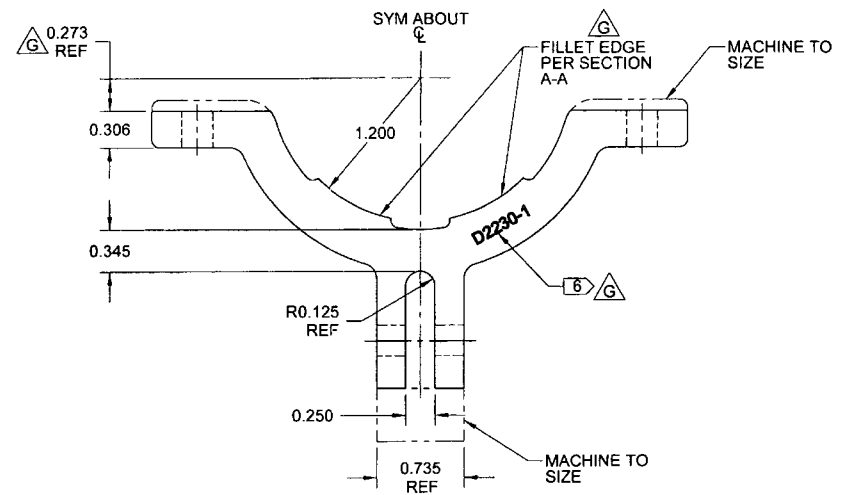
- NOTES:**
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
 - 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

8 7 6 5 4 3 2 1



SECTION A-A D4-2
SCALE 2X

R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

RELEASED
09/06/25/11

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE	SHEET 2 OF 3
DE APPR.		MOUNTING LUG	SCALE
DATE	09.01.16		NTS

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8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

RELEASED
09/06/25